	er ID 70531 2011 11:44:14 AM					•				Page 1
Item ID: Revision ID:	D3463-042	,	Accept				S	Setup Sta		
	Step Weldment Assembly 6/10/2011	110011101011001		Cust Item I Customer:	D:			Sto		
Approvals:	Process Plan:QC:	Date:// <i>Ole10</i>	Tooling: SPC (Y/N):		ate:		F	Run Sta Sto		
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3463	Rev B									
100 Large Fab Large Fab	Large Fab Memo Weld as	sembly as per dwg D3463 using	0.00 0.00 g DT8875				EZ_	11-7	7-6-	(No)
110 QC	QC9- Inspect visual Memo	per QSI004- Fusion Welds	0.00			ć	/L	1.07.	>క	
Quality Control 120 QC		ompleteness to step on W/O	0.00 Su	los (u c			(72)			
	Memo		_{0.00} δ u	la/uc			40	·		-

Dail Ac	Ospace	Liu							•
W/O:			WC	ORK ORDER CHANG	ES			*	·
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositio	n:	_ QA: N/C C	losed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
D.4.T.E.	0755	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
							·		
									-
L		-							_

Work Order ID 70531

Friday, June 10, 2011 11:44:14 AM



Page 2

Item ID:

D3463-042

Accept



Run

Qty

Setup Start Stop



Revision ID:

Item Name:

Required Date: 6/15/2011

Step Weldment Assembly

Start Date:

6/10/2011

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start

Stop



Date: _____

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Accept

Qty

Reject Reject Number

Insp. Stamp

Sequence ID/

Work Center ID

130

Operation Description

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Powdercoat Powder Coating

1- Mask areas indicated on dwg D3

Wing Walk as per dwg QSI005 4.4 Batc

140

HandFinish Hand Finishing

Memo

0.00

BL 11-7-7

150

0.00

Memo

QC3- Inspect Part Finish

0.00

Quality Control

Dail Aci	vapace	LU							
W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
 -									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	Date:	
	R	esolution:	Dispositio	n:	_ QA: N/C C	losed:	-	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	₹)			
DATE	STEP	Description of NC	1	Corrective Action Section	on B Sign		cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Date		ion C	Chief Eng	QC Inspector
								}	

Work Order ID 70531

Friday, June 10, 2011 11:44:14 AM



Page 3

Item ID:

D3463-042

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 6/15/2011

Step Weldment Assembly

Start Date:

6/10/2011

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: ___

Date: _____ Tooling:

SPC (Y/N):

Date: Date: Run

Start



Stop

Sequence ID/ Work Center ID

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: 6

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

W/O:			V	ORK ORDER CHANGI	ES				
DATE	STEP	PROC	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:	·	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQ	A :	Date:	
		esolution:							
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NCF	3)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
		·	·						
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			_				· · -		

Picklist Print

Friday, June 10, 2011 11:44:20 AM

Work Order ID: 70531

Parent Item:

D3463-042

Parent Item Name: Step Weldment Assembly



Start Date: 6/10/2011

Required Date: 6/15/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments: I	PP REV. A 05.	11.18 new issue	e E0	C 		_ ·							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-806	Biki 1 88 i	Purchased	No			100	Each	92.0000	2	8			
SS DOWEL PIN 1" LONG										· EZ	117-	B	
				Location		Loc	Oty	Loc Code					
				ST	110000		92 92		_	И			
03453-3		Manufactured	No		117606	100	92 Each	0.0000	1	4	_		
				•	70854	X >	٠			a	11-7-	-6	
levis 93453-5		Manufactured	No	•	,000,	100	Each	15.0000	1	4			
										Q.	11-7	-6	
lug				Location		Loc	<u>Oty</u>	Loc Code					
				WA023	50204		15		_	٦	_		•
03463-1		Manufactured	No		59204	100	15 Each	0.0000	1	4			
					69	948 X	7			Q	11-7	-6	
03463-3		Manufactured	No		·	100	Each	26.0000	1	4			
111111 1111 1111 1111 1111 1111 1111 1111 1111 1111 1111 1111 1111 1111 1111 111 Step										a	11-7-	-6	
				Location	Į.	Loc	Qty	Loc Code					
				WA025			26			2-			
					46269		26			-5	_		

W/O:	•		W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	1-14	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _	<u> </u>
	R	esolution:	Disposition	on:	_ QA: N/C CI	osed:		Date: _	
NCR:				ER NON-CONFORMA		R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	Verification Approv		
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector

Picklist Print

Friday, June 10, 2011 11:44:20 AM

Work Order ID: 70531

Parent Item:

D3463-042

Parent Item Name: Step Weldment Assembly



Start Date: 6/10/2011

Required Date: 6/15/2011

Start Oty: 4.00

Required Oty: 4.00

D3463-5



End Cap

Manufactured

No

Manufactured

100

Each

13.0000

D3463-7

Drag Arm



Loc Oty 13 13 100

Each

3.0000

Loc Code

Loc Otv

Loc Code

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			1,230						•	
			-							
Part No	•	PAR #:	Fault Cate	gory:	_ NCF	: Yes I	do DQ	A:	_ Date: _	
	R	esolution:	Dispositio	n:	_ QA:	N/C Clo	sed:		Date: _	
NCR:	·		WORK ORD	ER NON-CONFORM	ANCE	(NCR))			
DATE	STEP	Description of NC			tion B		Verific	ation	Approval	Approval
	SILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
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										ŧ



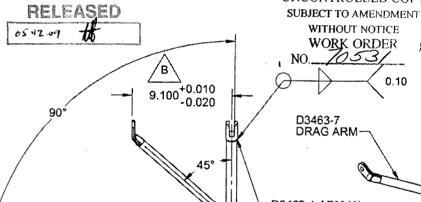
INSTALL P/N 238-806

DESIGI R		DRAWN BY RF	DART AEROSPACE LI HAWKESBURY, ONTARIO, CANA	
CHECK	(ED UL	APPROVED	DRAWING NO.	REV. B
			D3463	SHEET 1 OF 4
DATE			TITLE	SCALE
	05.1	12.05	STEP WELDMENT	1:8
Α	0	5.09.20	NEW ISSUE	
В	0	5.12.05	REVISE DIM.: D3463-5 WAS D3463-56	-

DOWEL PIN (TYP) V/G MASK THREAD **AREA** 1.045

CONCENTRIC HOLES MASK HOLES SHOP COPY RETURN TO **ENGINEERING**

UNCONTROLLED COPY



D3453-3 CLEVIS

pl 11-66-10

INSTALL SPAENAUR P/N 238-806 DOWEL PIN

0.06

(TYP)

150°

D3463-1 ARM (1)

D3463-3 STEP

D3463-5 END CAP (2 PLACES)

V_G

0.10

<u>D3463-042 STEP WELDMENT ASSEMBLY</u> D3463-041 OPPOSITE

NOTES:

WING WALK TOP SURFACE

0.30

D3453-5 PLUG

- 1) WELD PER DART QSI 004
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

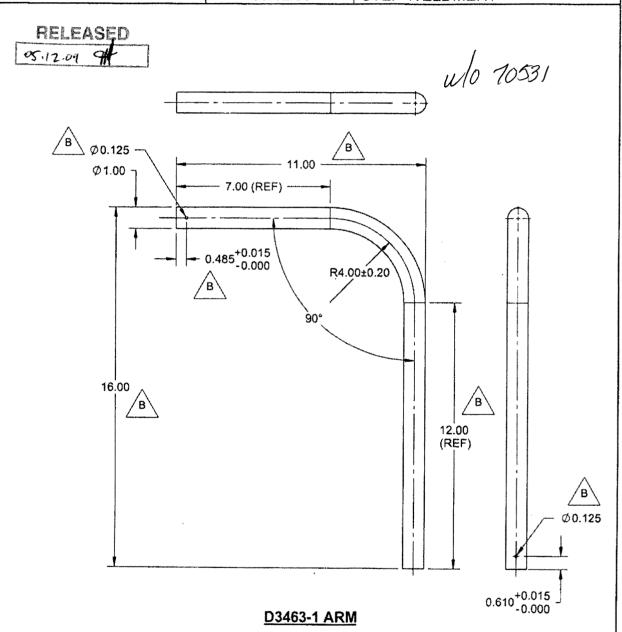
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Dail Moi	oopaoc	Liu							
W/O:			W	ORK ORDER CHANG	ES	,			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositio	n:	QA: N/C Cld	osed:		Date: _	
NCR:		·	WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	ion C	Chief Eng	QC Inspector
								Į.	



DESIGN RF	DRAWN BY RF	DART AEROSF HAWKESBURY, ONT.	
CHECKED	APPROVED	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.1	2.05	TITLE STEP WELDMENT	SCALE 1:4



NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

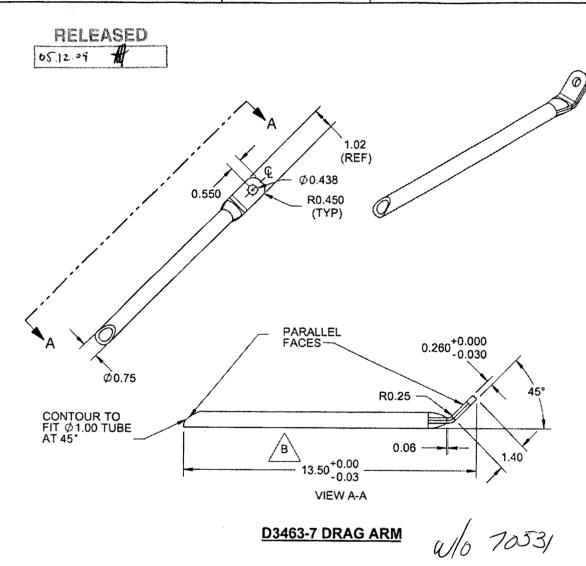
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Dail Ac	ospace	Liu							
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	on:	_ QA: N/C (Closed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section	on B Sign		cation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Date		ion C	Chief Eng	QC Inspector
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DESIGN RF	DRAWN BY RF	DART AEROSPA HAWKESBURY, ONTARIO	
CHECKED	APPROVED	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.	12.05	STEP WELDMENT	SCALE 1:4



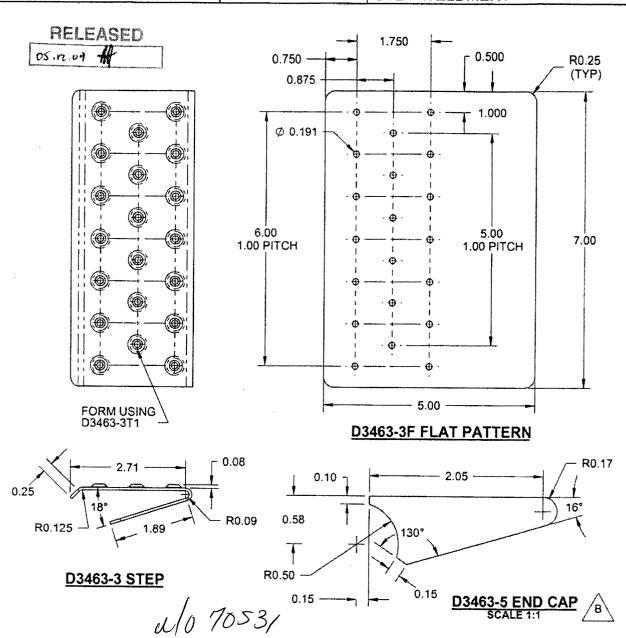
NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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W/O:			WC	ORK ORDER CHANG	iES					
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DATE	STEP Section A	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date		ion C	Chief Eng	QC Inspector
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHECKED	APPROVED	DRAWING NO. D3463	REV. B SHEET 4 OF 4				
DATE 05.1	2.05	STEP WELDMENT	SCALE 1:2				



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 4) ALL DIMENSIONS ARE IN INCHES
 50.005 TO 0.010
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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W/O:			W	ORK ORDER CHANG	ES		_		
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			WORK ORI	DER NON-CONFORMA	NCE (NC	R)			
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